



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D206-642-541
Job Sheet 196215



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/10/19

Job Tracking No:

Due Date: 7/19/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV G IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP REV:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF:JLM

Ship Via:

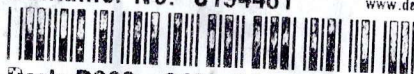
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/19/19		0.00	2.17	Skidtubes - 1		(D)
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
114	QC 5	1 pcs	7/19/19		0.00	0.00	QC 5 - 10		JUL 02 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
116	QC 10	1 pcs	7/19/19		0.00	0.00	QC 10 - 10		JUL 02 2019
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		



Container No: S194481



Part: D206-642-541

Job No: 196215

Serial No/Batch: S194481

Revision:

Inspector:

Exp Date:

Dart Aerospace Ltd.
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CANADA
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Instructions: FAA STC SA00475SE 18/10/17, TC STC SH98-4 Issue 2, EASA STC

120 Handfinish - 1-1 Chemical-B4B	1 pcs	7/19/19	0.00 0.68	QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	JUL 03 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	7/19/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	BF
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	

					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
150 Skidtubes - 2 - B4B	1 pcs	7/19/19	0.00 2.08	Skidtubes - 1 - B4B		DP
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		TF
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
160 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		BE
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
170 Skidtubes - 3 - B4B	1 pcs	7/19/19	0.00 2.17	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B	#1 MGL	
				Skidtubes - 4 - B4B		TF
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
180 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		BE
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
190 Skidtubes - 4 - B4B	1 pcs	7/19/19	0.00 2.75	Skidtubes - 1 - B4B		DP
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		MGL
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		BE
				Skidtubes - 6 - B4B		

				Skidtubes - 7 - B4B	
200 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	AUG 07 2019 DAS 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
210 QC 10	1 pcs	7/19/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	AUG 07 2019 DAS 50
				QC 10 - 58	9-89
220 Handfinish - 2-1 Pressure- B4B	1 pcs	7/19/19	0.00 0.45	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	AUG 08 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
230 Spray Paint - 2 - B4B	1 pcs	7/19/19	0.00 0.40	Spray Paint - 1 - B4B	RD 19-8-8
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
240 QC 14	1 pcs	7/19/19	0.00 0.00	QC 14 - 15	JUL 14-8-9
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
244 Handfinish - 3-1- WingWalk- B4B	1 pcs	7/19/19	0.00 0.50	QC 14 - 24	
				Handfinish - 3 - 1 - B4B	JUL 19-8-9
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
246 QC 3	1 pcs	7/19/19	0.00 0.00	Handfinish - 3 - 5 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				Plex 6/10/19 8:52 AM Dart.lajeunesse.marie	

						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	BEB 19-08-09
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
250 Handfinish - 4-1-Assembly-B4B	1 pcs	7/19/19	0.00	0.45		Handfinish - 4 - 1 - B4B	Jul 14 8-9
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	7/19/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	7/19/19	0.00	0.68		Handfinish - 4 - 1 - B4B	
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 -	

				B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	14-8-17
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
280 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
290 Packaging 3-1 - Stock - B4B	1 pcs	7/19/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

DAS
AUG 12 2019 40
9-89

				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
295 DC - 1 - B4B	1	7/19/19	0.00 0.00	DC - 1 - B4B	21
	pcs			DC - 2 - B4B	9-59
300 QC 21 - FG	1	7/19/19	0.00 0.00	QC 21 - FG - 21	DAS AUG 1 2 2019
	pcs			QC 21 - FG - 70	21
				QC 21 - FG - 53	9-59

Part Op 110 - (Skid tubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: 138989/139011 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 5- Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of skid tube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

114 - (QC5- Inspect part completeness to step on W/O)
 116 - (QC10- Inspect visual per QSI004- ground welds)
 120 - (Chemical Conversion Coat per QSI005 4.1)
 130 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Skid tubes) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere for 12 hours)
 160 - (QC5- Inspect part completeness to step on W/O)
 170 - (Skid tubes) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297". Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Skid tubes) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274. ****INSPECT FOR PIN HOLES IN WELD**** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (QC10- Inspect visual per QSI004- ground welds)
 220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch
 230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw,. 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5198114 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5198581
 240 - (QC14- Inspect Spray Paint)
 244 - (Wing Walk as per dwg QSI005 4.4 Batch 518549 T
 246 - (QC3- Inspect Part Finish)
 250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.
 260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts
 270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.
 280 - (QC5- Inspect part completeness to step on W/O)
 290 - (Identify as per dwg & Stock Location: _____) Location : FG073
 295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005
 300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using DT10280 and deburr.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1	5189763
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1	504373B
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B	5151355
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5188442
D3275-1	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5199330
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B	5051257
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5099573
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	FM137886-0
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	F147134
AN3C4A	Bolt	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5192134
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5057496
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5160607
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5114083
D3537-1	Wearpad	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B	5195627
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5195634
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	F164009
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5200829
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5171523
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5172574
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201005
NAS1149C0332R	Washer	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5193136
NAS1149C0463R	Washer	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5124667

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	3	0
	D3285-1	1	13	0
150-Skidtubes - 2 - B4B	D3282-041	1	1	0
	D2649	12	128	0
190-Skidtubes - 4 - B4B	D3275-1	12	104	0
	ALS4-1032-130	78	7,437	0
250-Handfinish - 4-1-Assembly-B4B	CCR264SS3-3	2	159	0
	CR3212-4-03	2	84	0
	D3415-041	1	9	0
	AN3C4A	80	858	0
270-Handfinish - 4-2-Assembly-B4B	AN4C5A	1	55	0
	D2646	1	32	0
	D3413-1	1	17	0
	D3537-1	9	59	0
	D3537-3	1	18	0
	D3672-1	2	1,677	0
	D4956-15	1	4	0
	D4956-23	1	10	0
	D4956-35	1	8	0
	D4956-39	1	1	0
	NAS1149C0332R	80	2,866	0
	NAS1149C0463R	1	279	0

Part Specifications

Specifications could not be found.

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Qty -041	Qty -043	Qty -045	Part Number	Description
X			D3274-041	SKIDTUBE ASSEMBLY
	X		D3274-043	SKIDTUBE ASSEMBLY
		X	D3274-045	SKIDTUBE ASSEMBLY (FOR PHI)
1	1	1	D2600-1-240	EXTRUSION
1	1	1	D2646	AFT CAP
12	12	12	D2649	CROSS BOLT SPACER
12	37	12	D3275-1	CROSS BOLT SPACER
1	1	1	D3282-041	FLOAT WEB
1	1	1	D3285-1	CAP
1	1	1	D3413-1	RING
1	1	1	D3415-041	NUT PLATE
9	9		D3537-1	WEARPAD
		1	D3537-11	WEARPAD
1	1		D3537-3	WEARPAD
		9	D3537-9	WEARPAD
2	2	2	D3672-1	WASHER
1	1		D4956-15	WEARSHOE
1	1		D4956-23	WEARSHOE
1	1		D4956-35	WEARSHOE
1	1		D4956-39	WEARSHOE
78	78	40	ALS7-1032-130	INSERT (or AK54-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	42	AN3C4A	BOLT
1	1		AN4C5A	BOLT
1	1	1	NAS1149C0463R	WASHER (AN960C416)
80	80	42	NAS1149C0332R	WASHER (AN960C10L)
2	2	2	CCR264SS3-3	RIVET
2	2	2	CR3212-4-03	RIVET
		1	MS27039C4-06	SCREW

GENERAL NOTES:

1. MATERIAL: N/A

2. FINISH:

ON -041/-043: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART QSI 005 4.2 BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4

ON -045: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER QSI 005 4.2.1 PAINT BLACK PER QSI 005 4.2.2 USING CA8213/F37038 CAMOFLAGE BLACK PER MIL-PRF-05285E TYPE I CLASS H. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4

3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

4. UNITS: INCHES UNLESS OTHERWISE NOTED

5. BREAK SHARP EDGES 0.005 TO 0.010 MAX

6. IDENTIFICATION: N/A

7. WEIGHT: FOR -041/-043 = 37.5 LBS

FOR -045 = 33.4 LBS

8. WELDING TO BE DONE PER DART QSI 004.

9. ALL HOLES DRILLED ON CENTERLINES.

10. DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

11. BOND D3282-041 FLOAT WEB INTO D3274-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.

12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291. ON -045, DO NOT DRILL HOLES OR INSTALL INSERTS FOR LONG WEARPLATES.

13. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.

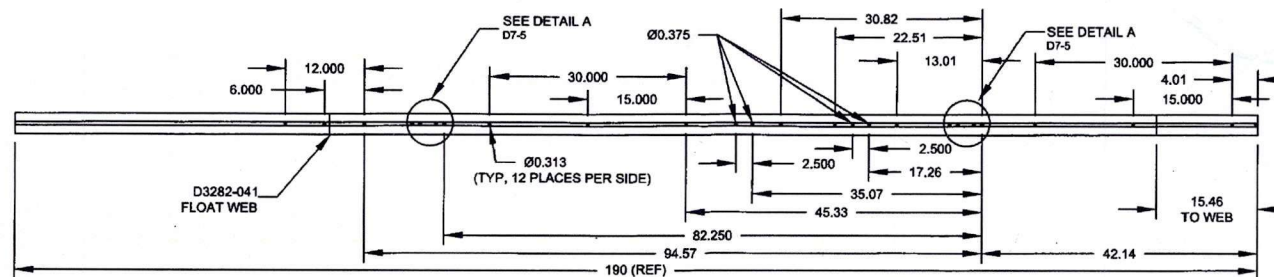
14. ON -045, APPLY COAT OF ROCKGUARD TO SKIDTUBE WHERE WEARPADS ARE INSTALLED.

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

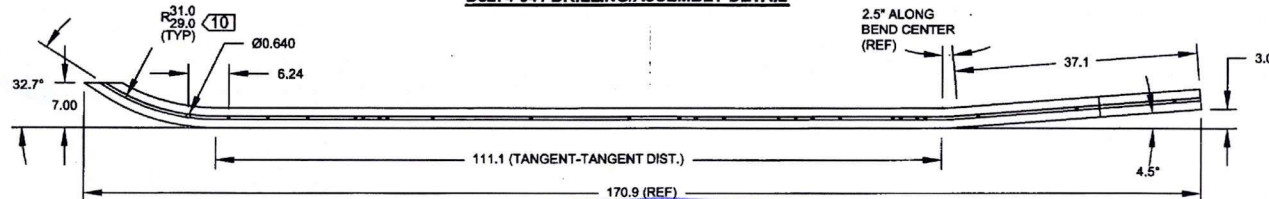
NO. 196215 M15
190610

G	ADD -045 CONFIGURATION (FOR PHI) ZN A5-4, A5-6 REVISE NOTE 2, 7 & 12, ADD NOTE 14 (ZN A8-1)	DS	16.04.25
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IIN-D206-642 REV Q	DB	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	06.12.19
C	ADD -043; NEW INSERTS	CP	05.03.16
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 1 OF 6
APPROVED	DS	TITLE	SCALE
DE APPR.	—	SKIDTUBE ASSEMBLY	NTS
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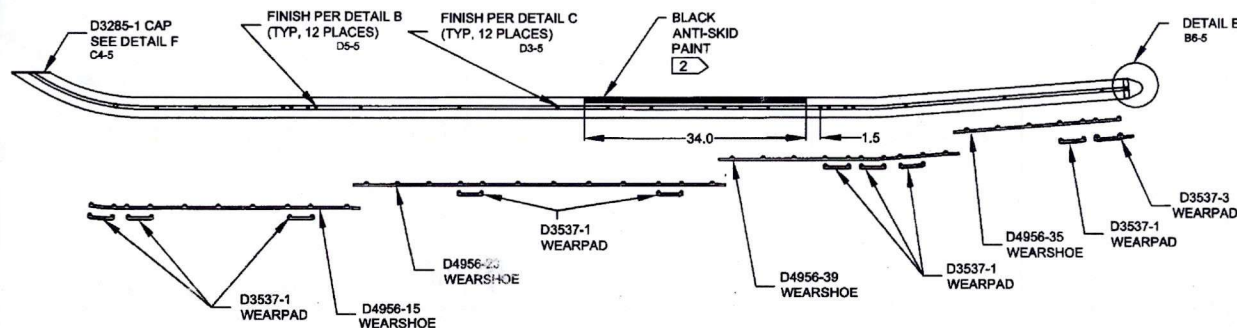
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ECN 16-616



D3274-041 DRILLING/ASSEMBLY DETAIL



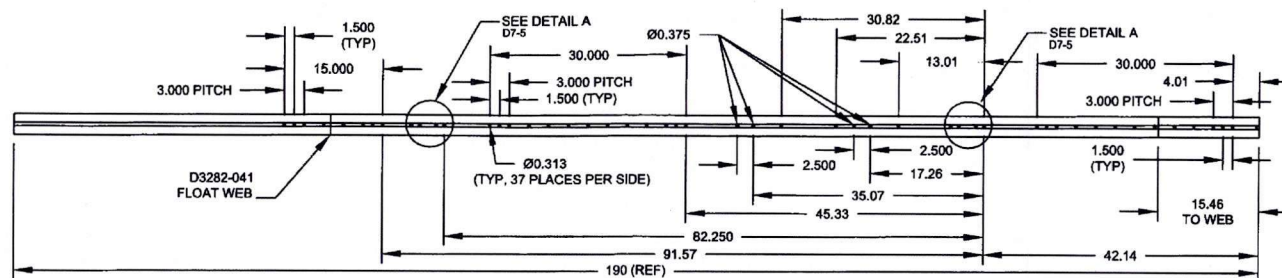
D3274-041 BEND/DRILLING DETAIL



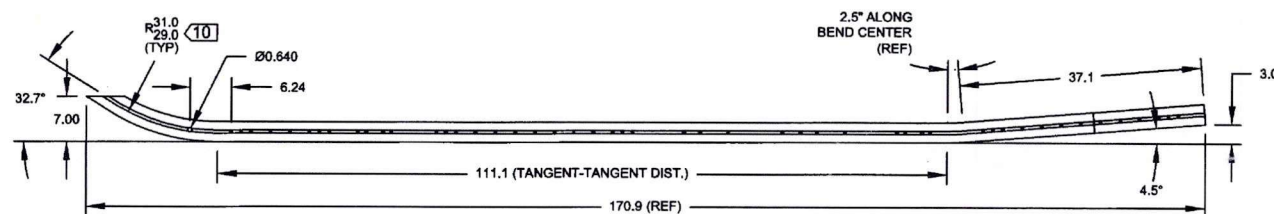
D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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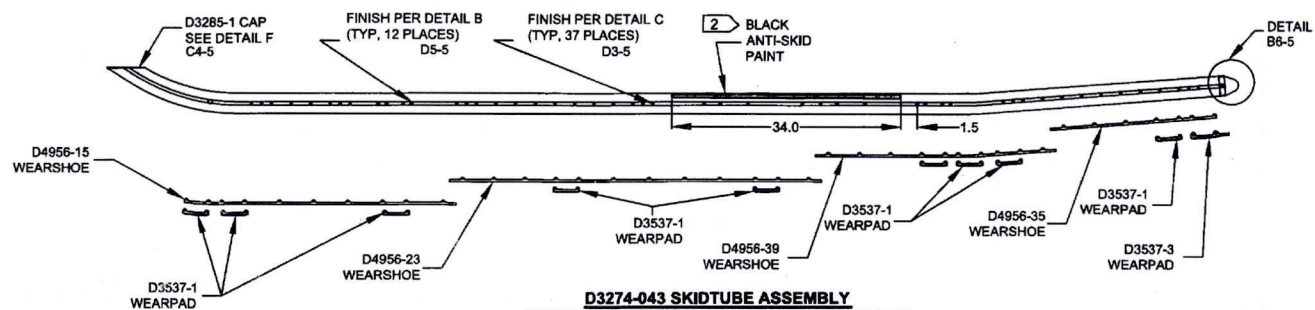
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D3274-043 DRILLING/ASSEMBLY DETAIL



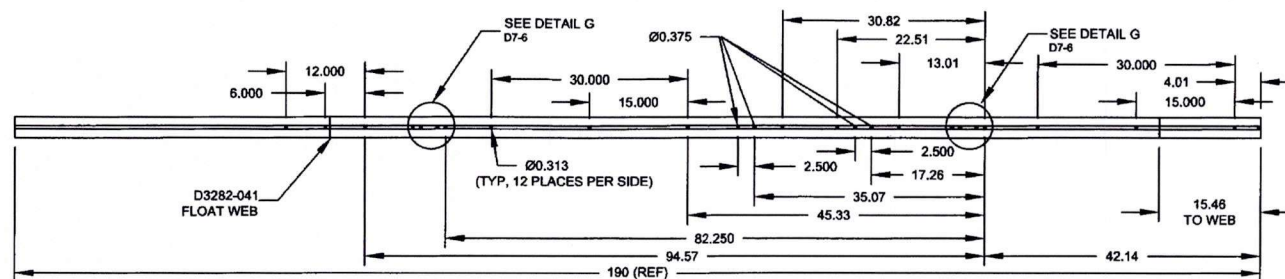
D3274-043 BEND/DRILLING DETAIL



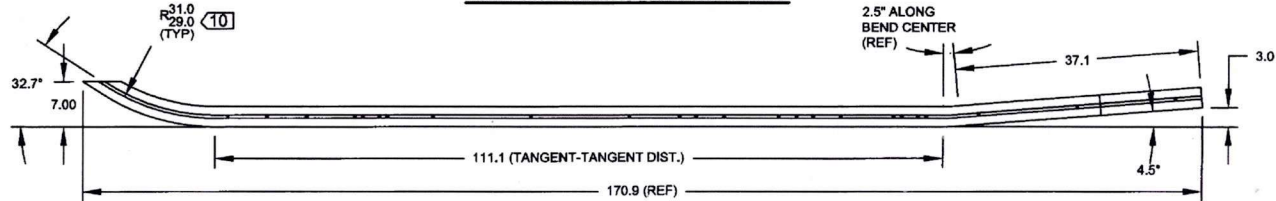
**D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

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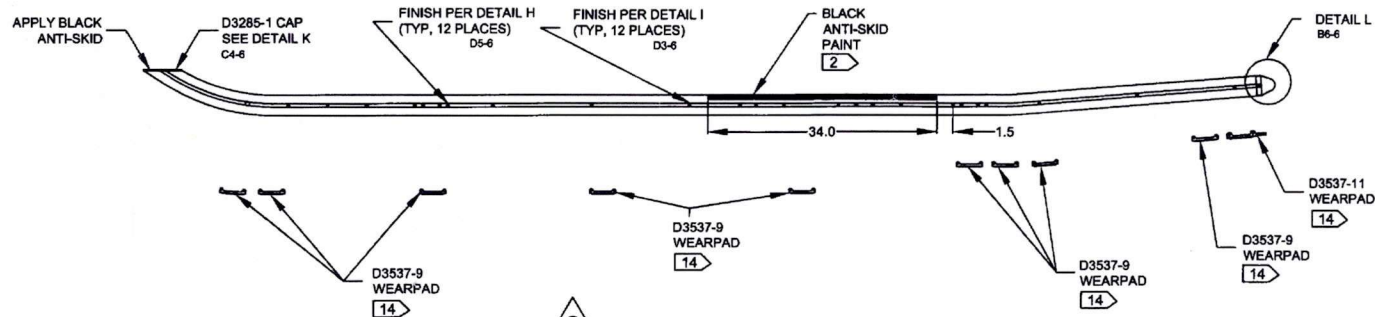
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D3274-045 DRILLING/ASSEMBLY DETAIL



D3274-045 BEND/DRILLING DETAIL

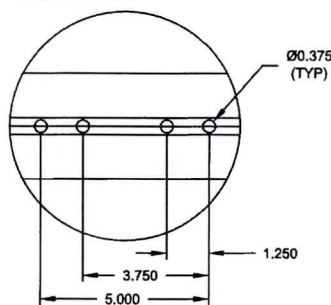


D3274-045 SKIDTUBE ASSEMBLY
(SEE DETAIL J FOR WEARSHOE INSTALLATION)

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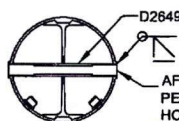
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MFG. APPR.	JLM	D3274	SHEET 4 OF 6
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DE APPR.		SKIDTUBE ASSEMBLY	NTS
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DETAIL A: DRILL DETAIL
D6-2, D3-2, D5-3, D3-3



DETAIL B
B6-2, B5-3

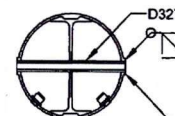
FOR Ø0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C
B5-2, B4-3

FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

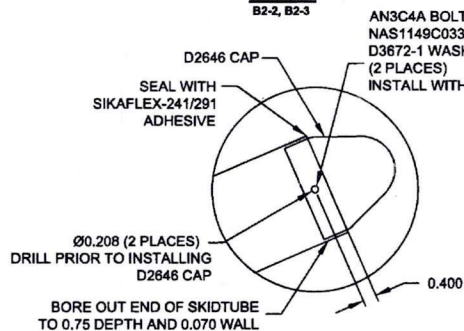
DETAIL D
A4-2, A4-3



ALST-1032-130 INSERT (1)
AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
(78 PLACES)

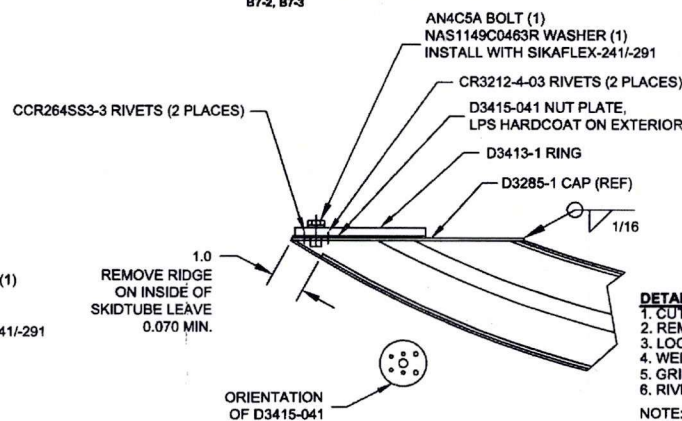
WEARSHOE/WEARPAD (REF) **G**

DETAIL E
B2-2, B2-3



AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
D3672-1 WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL F NOTES

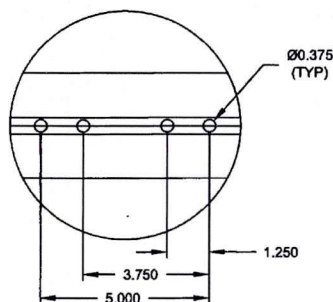
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

-041/-043 DETAILS

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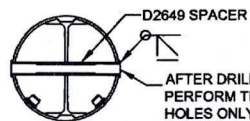
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DETAIL G: DRILL DETAIL
D6-4, D3-4



DETAIL H
B6-4

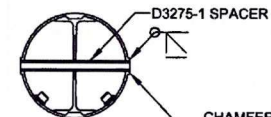
FOR Ø0.375 HOLES ONLY



1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL I
B5-4

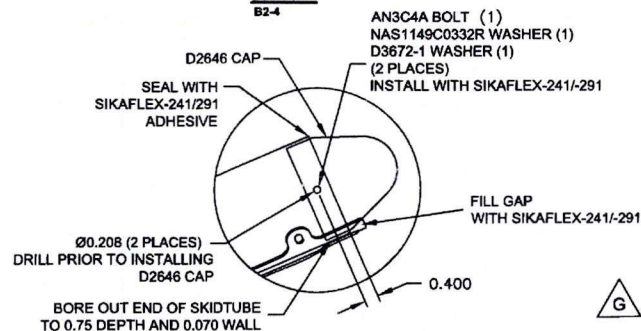
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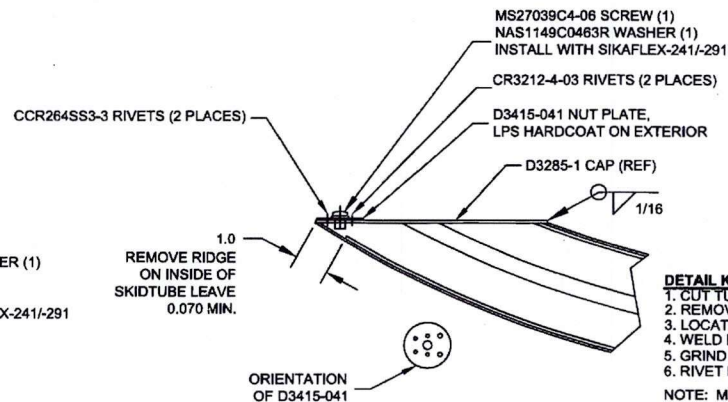
DETAIL J
A4-4



DETAIL L
B2-4



DETAIL K: END FINISHING DETAIL
B7-4



DETAIL K NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH



-045 DETAILS

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			